

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016336**Date Inspected:** 19-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 2W/3W Weld ID: F1, Face B
- 2). OBG Field Splice 4W/5W Weld ID: C1 & C2, Face B
- 3). OBG Field Splice 4W/5W Weld ID: B1, Face A
- 4). OBG Field Splice 5W/6W Weld ID: C1, Face A
- 5). OBG Field Splice 5E/6E Weld ID: C1 & C2, Face B

- 1). OBG Field Splice 2W/3W Weld ID: F1, Face B

The QAI performed verification Ultrasonic Testing (UT) of 30% of the length of OBG Field Splice 2W/3W Weld ID: F1 from Face B. Weld F1 was verified by the QAI and found to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date.

- 2). OBG Field Splice 4W/5W Weld ID: C1 & C2, Face B

The QAI periodically observed ABF personnel performing Plasma Cutting and grinding to remove the backing bar and prepare a groove for back welding. The work at this location was in process for the remainder of the QA Inspectors shift.

- 3). OBG Field Splice 4W/5W Weld ID: B1, Face A

The QAI periodically observed QC Inspector Jesse Cayabyab performing UT from the A Face of OBG Field

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Splice 4W/5W Weld ID: B1. The QAI periodically observed that Mr. Cayabyab performed the required shear wave testing during the testing for weld soundness utilizing a .63 x .75 rectangular transducer. The UT examination was completed from face A during the QA Inspectors shift and the work at this location appeared to be in general compliance with contract documents.

4). OBG Field Splice 5W/6W Weld ID: C1, Face A

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) performing welding per the Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position of fill and cover passes on weld ID: C1. See photo below. The QAI observed QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3042B-1. The QAI observed the QC Inspector monitoring and recording the welding parameters and observed the following: 24.2 welding volts, 250 welding amps and travel speed of 280mm/min. The QAI observed that the work at this location appeared to be in general compliance with contract documents.

5). OBG Field Splice 5E/6E Weld ID: C1 & C2, Face B

The QAI periodically observed QC Inspector Tom Pasqualone performing Magnetic Particle Testing (MT) on the B face (exterior) of OBG Field Splice 5E/6E Weld ID: C1 & C2. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. QC MT was complete at this location and the QAI observed that the work appeared to be in general compliance with contract documents.



Summary of Conversations:

Conversations on this date with various Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer